Work Order I August-06-13 11:05		46 7	2./	7	* 105	467*						Pagel I
Item ID: D46 Revision ID: Item Name: Was	008-7 her		10°	Accept		*N900	040	100)* ፡	Setup Star Sto	1.71	S1*
Start Date: 8/00 Required Date: 8/20 Reference:		Start Qty: 24/00/ Req'd Qty:/24/00	*24* *24*			Cust Item [] Customer:) :				10	. 12
	ocess Plan	: Wrユ	Date: 13 08-06	Toolin		Da	te:		I	Run Star Sto	, , , , , , , , , , , , , , , , , , ,	R1* R2*
Sequence ID/ Work Center ID Draw Nbr	J	Operation Description ion Nbr	<u> </u>	Set Rui	Up/ 1 Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D4008 100 *100* Hardinge Hardinge CNC Lathe Sma	C	Memo		0.00	(AS (40 8-8	3/08/	07		53	_	- ·— ·	
*110 *110* QC QC Quality Control	,	QC2- Inspect parts off ma	ichine FAI/FAIB	0.00	(DAS 400	13/08	107		<u>5</u> 3	_ Ø		<u></u> .

-11

NCR: Y	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											
										QA Closed:	Date	:
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part No				Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			Finishing	Pro Rec/Sto	Engineering Quality Other			
Root				Descri	ption of work order update	П	Initial	Actio	n	Sign &		
Cause	Da	te Step	Qty	(or Non-conformance	Ch	nief Eng	Descrip	<u>tion</u>	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						AUI	LT CATE	GORY				
Landir	ng Gear				General		_		_	_		 3
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	Torque Waves in Extrusion			Drawing		Out of C	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord (11gust-06-13-7				*10!		Pa			
ltem ID: Revision ID; Item Name: Start Date: Required Date: Referencc:	D4008-7 Washer 8/06/13 8/20/13	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*	Accept	*N90004010 Cust Item ID: Customer:	∩* Setu	Stop	*NS1* *NS2*	1
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	Date:	Run	Start Stop	*NR1* *NR2*	r: k!
Sequence ID/ Work Center II 120 *120* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00	Tool ID Tool # Plan Code			Reject Insp. Number Stamp	
120 Packaging Packaging		Identify as per dwg & Sto	ick Location: <u>6A</u>	0.00		.5 <u>3</u> ¥_		LI 130s	? ; 7
40 *140* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00		M	5_13 MUJ	13-08-08	- - - - - - - - - -

NCR: Yes / No	WORK ORDER NON-CONF	DQA: FORMANCE / LIPDATE	Date:
NCK. 163 / NO	WORK ORDER HOR COR	QA Closed:	Date:
Work Order:	DISPOSITION	AGAINST DEPARTMENT/PR	ROCESS
Work Order.	Rework	Skid-tube Crosstube	Water Jet Engineering

Work Orde	er.					DISPOSITION	1	AGAINST DEPARTMENT/PROCESS							
Part I	ِ ۰o۰					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		4	Water Jei d. Eng. Coor re/Packaging Supplie		Engineering Quality Other
Root	_				Descri	ption of work order update	1	nitial	·Act	tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	on	QC Inspector
Doc/Data										<u></u>					
Equip/Tooling					ĺ										į
Operator										-				,	
Material]												
Setup]												
Other							1								
Process			[1										
Supplier			ļ												
Training]												
Unapproved			<u>l</u> .			-:- <u></u>									
						F.	AUL	T CATE	GORY						
Landi	ng (ear			_	General		i		,		٦	••	_	1
	oxdot	Bending				Bend		Grain				Ovalized		\perp	Pressure/Forced
		Centre No	ot Concer	ntric to	O/S	BOM/Route	Щ	Hardwa	re			Over/Under			Temperature/Cure
1		Cracks				Broken/Damaged	Ш	Inspect	ion incomplete			Part Incorre	ct		Weld
	ᆫ	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/U	Unclear	_	Part Lost/Mi	issing		Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination		Mainte	enance			Part Moved			
		Heat Trea	ıt			Countersink		Mislabe	eled			Positioned V	Vrong	_	•
		Inspection	n Strip in	Tube		Cut Too Short		Misread	3			Power Loss/	Surge		Other
		Ripples in	Bend			Drill Holes		Offset							
		Torque W	/aves in E	extrusio	ก [Drawing		Out of 0	Calibration						
		Turning S	equence			Finish		Out of 9	Sequence						<u> </u>
Wave/Twist in Tube			Folio		Outside	Dimensions									

STATIST PRIME

August-06-13 11.05.50 1M

Work Order ID: 105467

D4008-7

Parent Item Name: Washer

105467

D4008-7

Start Date: 8/06/13

Required Date: 8/20/13

Start Qty: 24.00

Required Qty: 24.00

Comments:

Parent Item:

JPP REV:A NEW ISSUE 10-02-02 JLM VERIFIED BY:EC IPP Rev:B

10.05.03 as per ECN10-562 DD verified by:EC

IPP REV:C 12.03.07

AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No		<u> </u>	100	- + f	20.4900	0.028	0.707368			·- · -
MDFI RIN	IR1 nnc)				ł			**	_	0AS 40	13/0	207
Delrin Round Bar 1"						1					7.0		

Loc Oty

20.49

20.49

Location MAT018

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Loc Code

											DQA:	Date	e:	
NCR: Y	'es	/ No				WORK ORDER NON-C	CON	NFOR!	AANCE / UPI	DATE	QA Closed:	Date	<u> </u>	
					1	<u> </u>					QA Closed.		··-	
Work Orde	ar.					DISPOSITION				AGAINST DE	DEPARTMENT/PROCESS			
WOIN Olde						. Rework	ork Skid-tube Crosstube			Crosstube		Water Jet	Engineering	
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	_			-		Use-as-is	1	Therm	oforming	Finishing	Rec/Stor	e/Packaging	Other	
NCR N	۰ No					Work Order Update	Large Fab Composite			Composite		Supplier		
Root	\neg	-			Descri	ption of work order update	l:	nitial	Act	tion	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector	
Doc/Data														
Equip/Tooling														
Operator														
Material	\Box													
Setup														
Other	Ц	!											1	
Process	_													
Supplier	4		ļ										1	
Training	Н			,					1:					
Unapproved			<u> </u>	<u> </u>			1	T. CATE	2004		<u>, </u>		<u> </u>	
				-			AUL	T CATE	JURT				<u> </u>	
Landi:						General Bend		Grain			Ovalized	Г	Pressure/Forced	
		Bending Centre No	at Cancar	atric to		BOM/Route	-	Hardwa	ro		Over/Under	tolerance	Temperature/Cure	
	-	centre int Cracks	or concer	ונווכ נטי	U/3 -	Broken/Damaged	\vdash	1	on incomplete	<u> </u>	Part Incorred	<u></u>	Weld	
	\vdash	Crushed/	Crimpod		-	Burrs	\vdash	1	ions Incomplete/	Unclear	Part Lost/Mi	<u>-</u>	Wrong Stock Pulled	
	—	Cuffs	cimped		 	Contamination	\vdash	Mainte		-	Part Moved			
	Н	Heat Trea	ı t		-	Countersink	\vdash	Mislabe		·	Positioned V	Vrong		
	Н	neat Trea		Tube	<u> </u>	Cut Too Short	-	Misread			Power Loss/	_	Other	
	\vdash	Ripples in		·use		Drill Holes	\vdash	Offset	-	<u> </u>	J. 2.1.2. 22337			
	1 1				ı	10.111.10100	1							

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	105467
Description: Washer	Part Number:	D4008-7
Inspection Dwg: D4008 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.00	+/-0.030	1,002				
Ø0.18	+/-0.030	. 182				
0.125	+/-0.010	. 129				
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	-			,		
	- بهران <u>- بهران - بهران - بهران - بهران - بهران - بهران - به ا</u>					=======================================
						

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Preliminary Approval:)	174	Audited by:	40 9-8 ⁰	Measured by:
Date:	8.7	13.	Date:	13/08/07	Date:

Rev	Date	Change	Revised by	Approved
Α	10.08.03	New Issue	KJ	
В	12.03.08	Dwg Rev updated	KJ) D	
С	13.05.08	Dwg Rev updated	KJ CXX	<u> </u>

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ME ALL SES 0 -- 0.125 --Ø0.18 13-08-06 13-08-06 **D4008-7 WASHER** L 1 2012 -03- 0 2 L DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. DESIGN NOTES:
1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, Ø1.00 ROUND BAR, BLACK
REF DART SPEC M-DELRIN-R1.000 DRAWN CHECKED REV, C REF DART SPEC M-DELRIN-R1.000
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.00 ibs D4008 MFG. APPR. SHEET 6 OF 10 TITLE APPROVED SCALE SPLASH GUARD DE APPR. DATE 12.01.17 COPYRIGHT © 2018 BY DART AEROSPACE LTD
PHI STEAMER & FRANT HO CONFEDENCE, HO B BEPLED ON THE STREET CONTROL
HOT TO BE USED FOR HER PLANTED TO CONFEDENCE OF COMMANDATION TO THE PROPERTY OF TH

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